

# Work Order ID 74741

Wednesday, October 05, 2011 2:37:37 PM



Page 1

Item ID: D3774-3

Accept



Setup Start



Revision ID:

Item Name: Seat Back, LH/RH

Stop



Start Date: 10/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 11-10-5

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3774

Rev B

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up machine program D3774-3 □ Set up clamping frame as per folio

x4

Wh.  
11/10/20

110

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

x4

Wh.  
11/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
2/1/2								

**NOTE:** Date & initial all entries



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**NOTE:** Date & initial all entries

Wednesday, October 05, 2011 2:37:37 PM

Page 3

0.00

## Quality Control

x4 \_\_\_\_\_ Sh  
11/10/24

24 \_\_\_\_\_ Dh \_\_\_\_\_  
11/10/26

(x4) \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 74741**

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Page 4

Item ID: D3774-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Back, LH/RH

Start Date: 10/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg & Stock Location: 81257 0:00

Packaging

Memo

0.00

Sp 11-10-31

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/31  
MF  
11-10-31

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**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, October 05, 2011 2:37:42 PM

Page 1

Work Order ID: 74741

Parent Item: D3774-3

Parent Item Name: Seat Back, LH/RH



Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD  
IPP REV. B Dwg. Update 08.08.19 DL  
Add Step 115 Dry Material 10/04/21 DL

Ipp Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04 Purchased No

100 sf 902.1763 10.667 42.668



GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT018

902.176289

902.176289

116236

42.668 58 16

DL  
11/10/2011

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	14741
Description: Seat Back		Part Number:	D3774-3
Inspection Dwg: D3774	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DL Date: 11/10/20

#### TRIMMING SECTION

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	1.3	+/-0.100	1.394"	✓		Visual DL-02	
	33.9	+/-0.100	33.875"	✓		TAPE DL-01	
#11	0.085	Min	0.091"	✓		CAL TH-DT	
#12	0.100	Min	0.114"	✓		CAL TH-DT	
12	0.100	Min	0.110"	✓		CAL TH-DT	
12	0.100	Min	0.110"	✓		CAL TH-DT	
12	0.100	Min	0.109"	✓		CAL TH-DT	
12	0.100	Min	0.108"	✓		CAL TH-DT	
12	0.100	Min	0.108"	✓		CAL TH-DT	
12	0.100	Min	0.102"	✓		CAL TH-DT	
#10	0.100	Min	0.069"	✓		CAL TH-DT	

Measured by: DL Date: 11/10/20

Audited by: JB Date: 11/10/20

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	
B	09.05.19	Dimension 17.4 removed	KJ	

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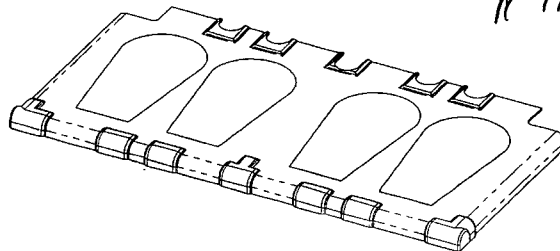
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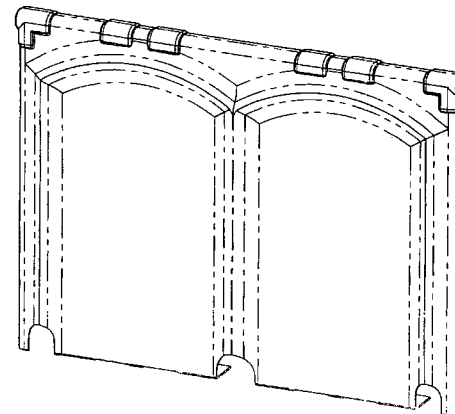
**NOTE:** Date & initial all entries

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 74741

*N 11-10-5*



D3774-1 SEAT BOTTOM



D3774-3 SEAT BACK

**RELEASED**  
*08-08-11/11*

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES		PH	08.07.25
A	NEW ISSUE		HS	08.06.23
REV	DESCRIPTION		BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>PH</i>			
CHECKED	<i>PH</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>PH</i>	D3774	SHEET 1 OF 3	
APPROVED	<i>PH</i>	TITLE	SCALE	
DE APPR.	<i>PH</i>	SEAT	NTS	
DATE	08.07.25		<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

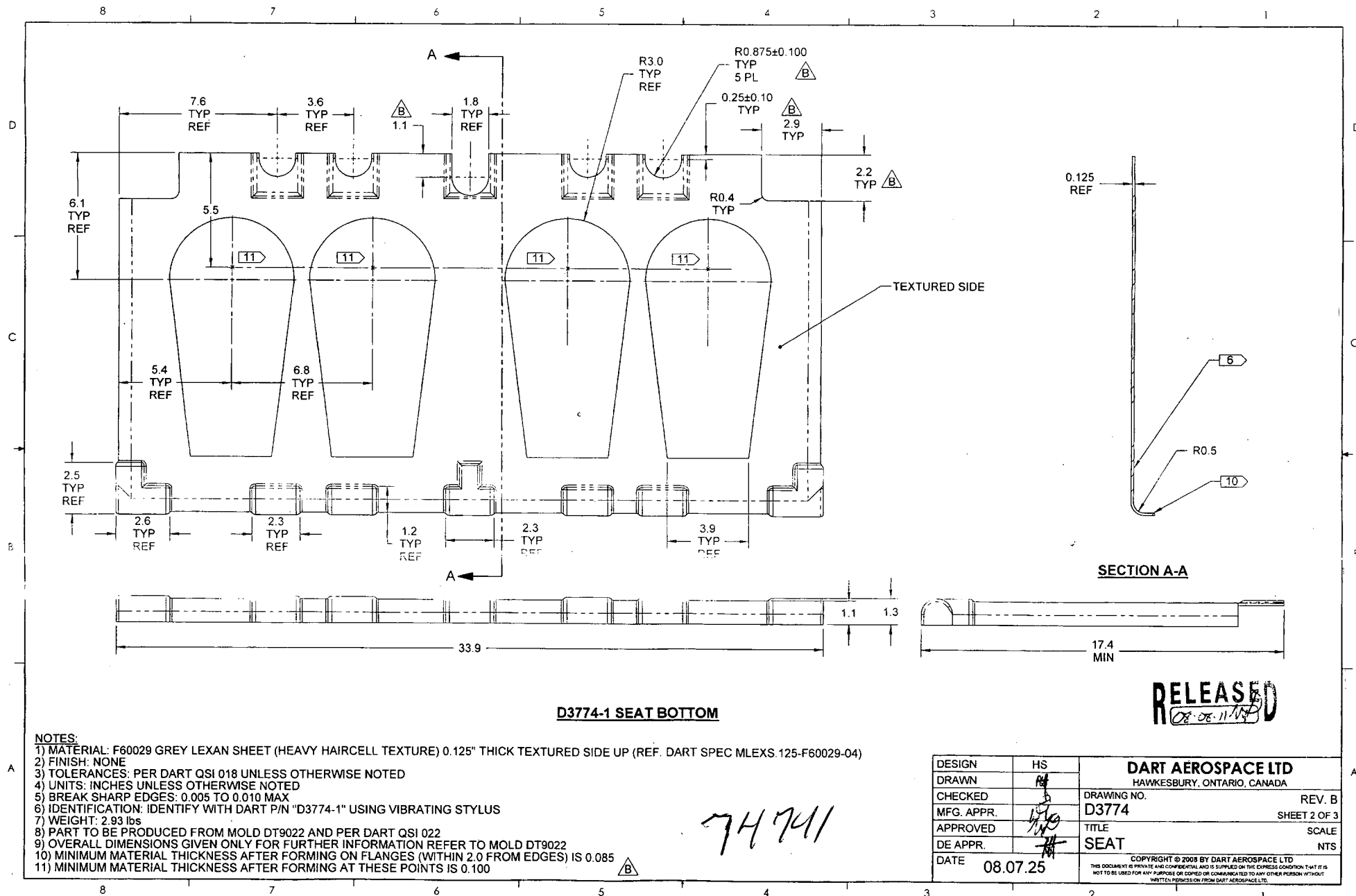
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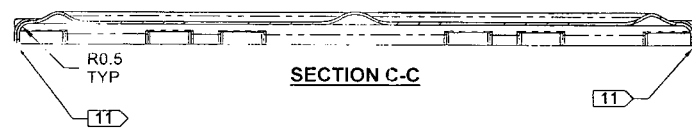
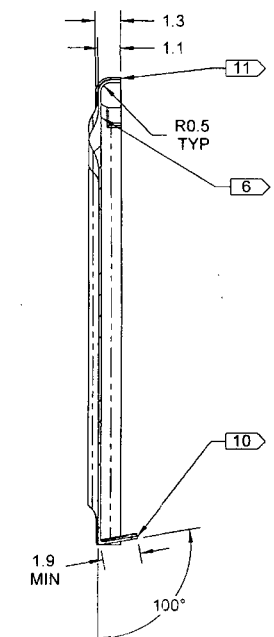
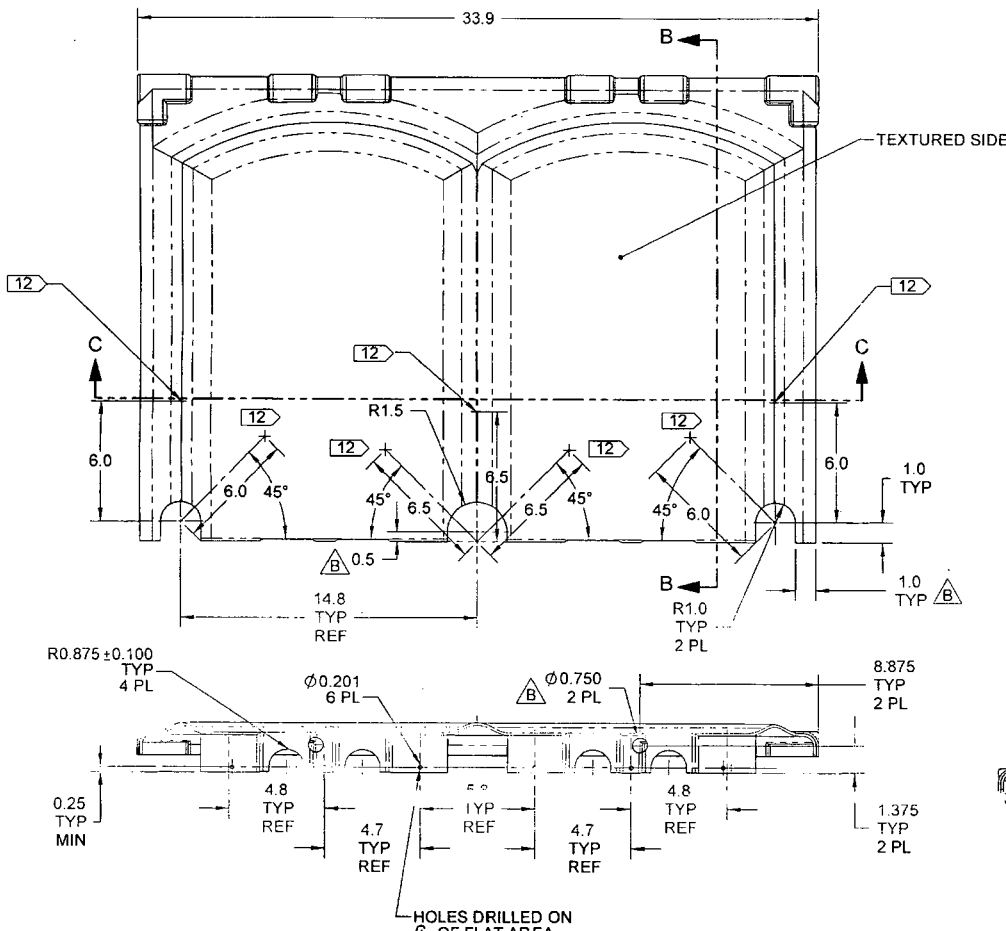
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8 7 6 5 4 3 2 1



**D3774-3 SEAT BACK**

- NOTES:**
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
  - 7) WEIGHT: 4.82 lbs
  - 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
  - 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
  - 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
  - 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
  - 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

7474/

**RELEASED**  
08-05-11

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	PE	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3774	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT	NTS
DATE	08.07.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

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